



Dart Hawkesbury
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D1049

Job Sheet 168300



Part No: D1049

Job Qty: 10 ea

Part Name: Saddle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/20/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV -- IPP RevC 02.04.10 Re-format NG

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		11/18/17	0.00	0.00	Start Up Machining		
100	Bandsaw	10 pcs		11/18/17	0.00	0.24	Bandsaw1		
110	CNC Vertical Machining	10 pcs		11/18/17	0.13	1.57	HAAS 1		
130	QC	10 pcs		11/18/17	0.00	0.00	QC8		
140	HandFinish	10 pcs		11/18/17	0.00	0.24	HandFinish1		
150	Powdercoat	10 pcs		11/20/17	0.00	0.14	Powdercoat4		
160	QC	10 pcs		11/20/17	0.00	0.00	QC3		
170	Packaging	10 pcs		11/20/17	0.00	0.00	Packaging3		
180	QC21-SA	10 Ea		11/20/17	0.00	0.00	QC21		

Part Op 100 - Cut Blanks: 2.000" long

Descriptions: 110 - 1-Machine as per folio FA217 & Dwg D1049

150 - START TIME: 1:20

FINISH TIME: 1:50

OV: T: 320°

M135418. DEC 14 2017

170 - LOCATION: GA

GA

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B0.750X00.250	2	14	0	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle	0.203Inches + 0.005 - 0.000	0.208 0.203	Diameter	
2	Saddle	1.380Inches $\pm$ 0.010	1.390 1.370		
3	Saddle	0.750Inches $\pm$ 0.030	0.780 0.720		
4	Saddle	0.250Inches $\pm$ 0.030	0.280 0.220		
5	Saddle	0.900Inches $\pm$ 0.030	0.930 0.870		
6	Saddle	0.170Inches $\pm$ 0.030	0.200 0.140		
7	Saddle	0.250Inches $\pm$ 0.010	0.260 0.240	Radius	
8	Saddle	0.380Inches $\pm$ 0.030	0.410 0.350		
9	Saddle	1.800Inches $\pm$ 0.030	1.830 1.770		

Plex 11/14/17 7:48 AM dart.boucher.sylvie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

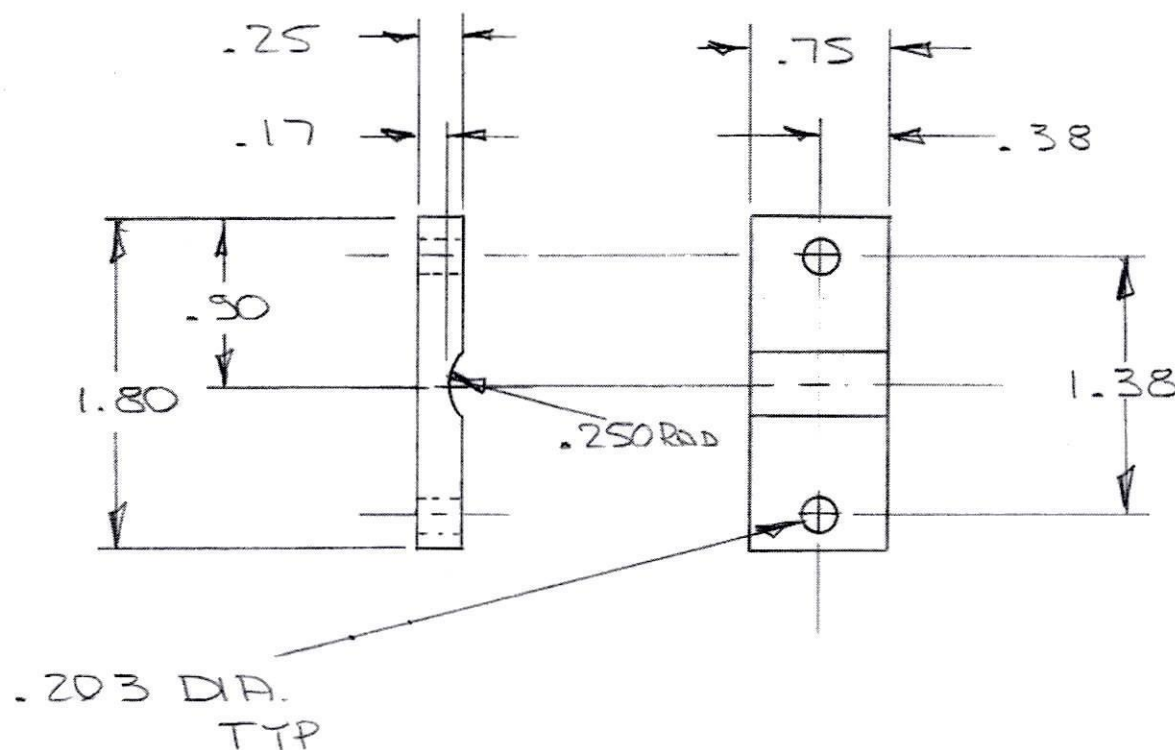
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

RELEASED
97/08/02 BW



MATERIAL : 5052-H32

FINISH : POWDER COAT



REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
DRAWN			BASIC CODE		CONTRACT NO.		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA		
APPROVED			D-DIMPLE DIGIT-NO OF SHEETS C-COUNTERDRILL		DATE 1992				
DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		LENGTH DASH NO. IN-SPOTFIELD		DESIGN		TITLE		
	GENERAL		BASIC CODES		STRESS		CODE		
	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS .015 MAX 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH — 5 — 7/64 5. HOLES PER AND 10247		1. TOLERANCES — .001 2. ANGLES .001 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005		CHECKED		DWC NO D1049		
	REPORT ALL DISCREPANCIES — DO NOT SCALE				CLIENT		REV.		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					